

PRELIMINARY ISSUE

Page 1

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Tooling:**Date:**

Date:

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

11/10.09.16

0.00

۵۶۳. ۱۵۵۶

Prog Rev: DA1

PA2 same dim. as PA1

10.09.12

1310-9-14

2

0.00

Quality Control

0.00

1310-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61965

Monday, September 13, 2010 11:15:45 AM



Page 3

Item ID:	D4173-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Pod Radalt Mounting Plate					
Start Date:	9/13/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	9/20/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location: <u>WA</u> <u>use on w/o 61963</u>	0.00							
Packaging 	Memo	0.00				2	Ø		
Packaging									
160 	QC21- Final Inspection - Work Order Release	0.00							
QC 	Memo	0.00							
Quality Control									

10/09/29

WA-09.20

POSITIVE RECALL

EFFECTIVE 09/13 AUTH U

RELEASED 1 DATE 10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 11:15:50 AM

Page 1

Work Order ID: 61965



Parent Item: D4173-1



Parent Item Name: Pod Radalt Mounting Plate



Start Date: 9/13/2010

Required Date: 9/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	101.4340	0.41	0.863158			
6061-T6 .063 Sheet												18 10-9-14	

Location

Loc Qty

Loc Code

MAT21

101.434

113608

101.434

113608

②

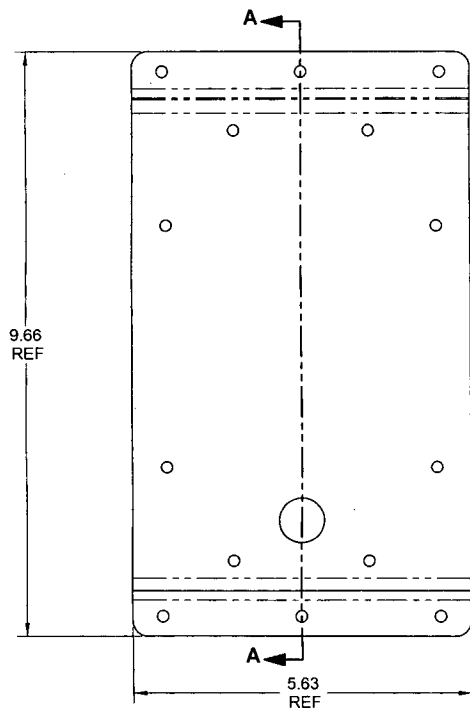
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

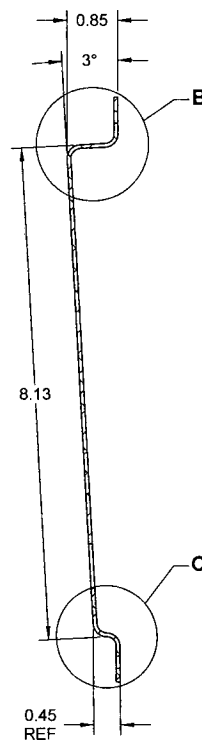
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

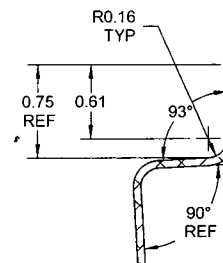
NOTE: Date & initial all entries



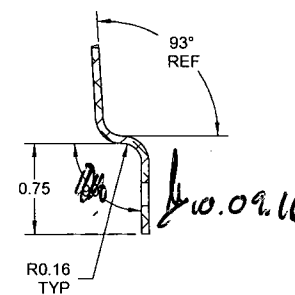
D4173-1 POD RADALT MOUNTING PLATE



SECTION A-A



**DETAIL B
SCALE 2X**





**DETAIL C
SCALE 2X**

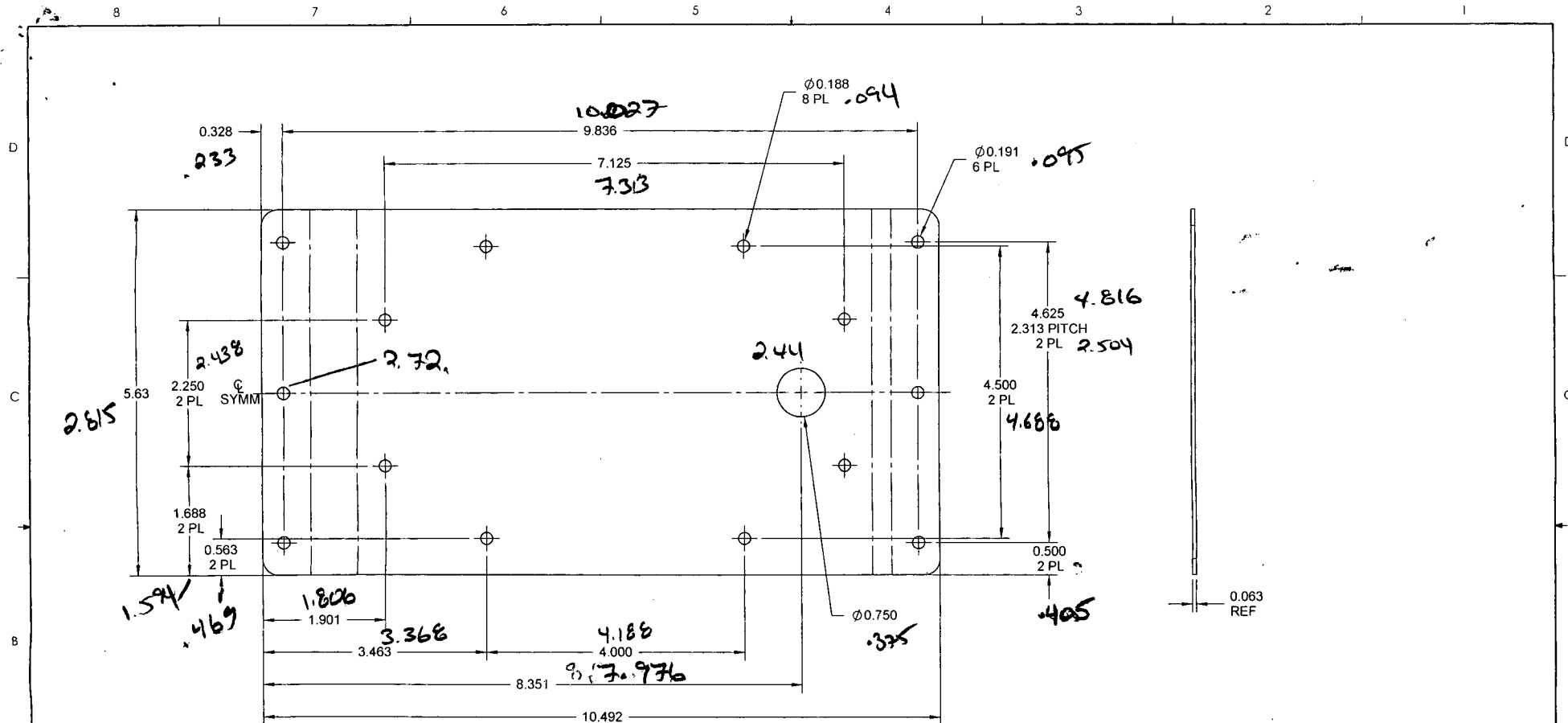
PRELIMINARY ISSUE
10.09.08

NOTES:

- 1) MATERIAL: MAKE FROM D4173-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

10/6/965

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4173	SHEET 3 OF
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D4173-1F POD RADALT MOUNTING PLATE FLAT PATTERN

PRELIMINARY ISSUE

10.09.08

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

DESIGN	<i>16</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. PA1 D4173 SHEET 4 OF 7 TITLE SCALE POD RADALT MOUNTING PLATE ASSY NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON OR ENTITY</small>
DRAWN	<i>B</i>	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.09.01	

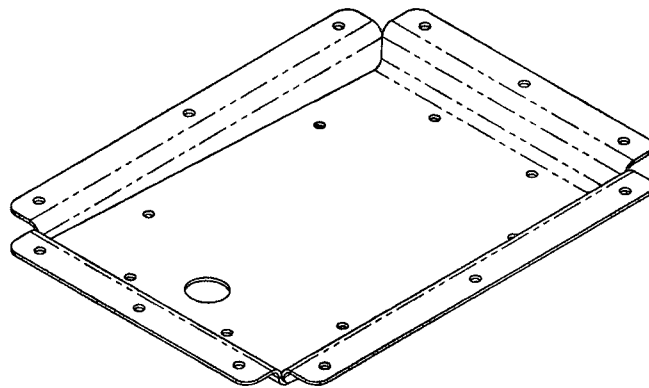
DART AEROSPACE LTD		Work Order: 61965
Description: Pod RADALT MOUNTING PLATE		Part Number: D4173-1
Inspection Dwg: D4173-1 Rev: p41		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

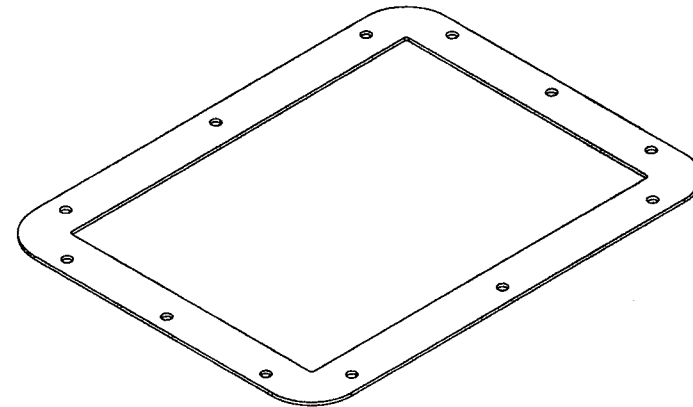
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.189	x		✓ HB02	
Ø .191	+ .005 - .001	.192	x		✓	
Ø .750	+ .008 - .001	.750	x		✓	
.328	± .010	.330	x		✓	
9.836	± .010	9.832	x		✓	
7.125	± .010	7.121	x		✓	
4.625	± .010	4.624	x		✓	
2.313	± .010	2.313	x		✓	
4.500	± .010	4.503	x		✓	
.500	± .010	.503	x		✓	
10.492	± .010	10.496	x		✓ PROD02	
8.351	± .010	8.351	x		✓ PROD	
4.000	± .010	4.004	x		✓	
3.463	± .010	3.465	x		✓	
1.901	± .010	1.901	x		✓	
.563	± .010	.564	x		✓	
1.688	± .010	1.688	x		✓	
2.250	± .010	2.248	x		✓	
5.63	± .030	5.630	x		✓	
.063	± .010	.060	x		✓	

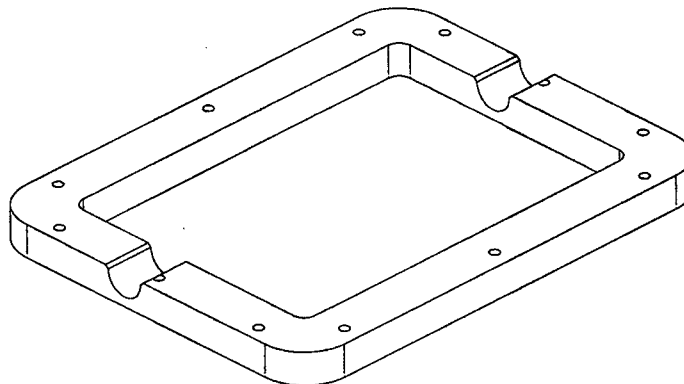
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-14	Date: 10/07/14	Date:	N/A
inspected to p41 Dwg only		Revised by: KJ/JLM	Approved:
Rev A	Date	Change	
		New Issue	



D4173-041 POD RADALT MOUNTING PLATE ASSY



D4173-3 POD RADALT DOUBLER

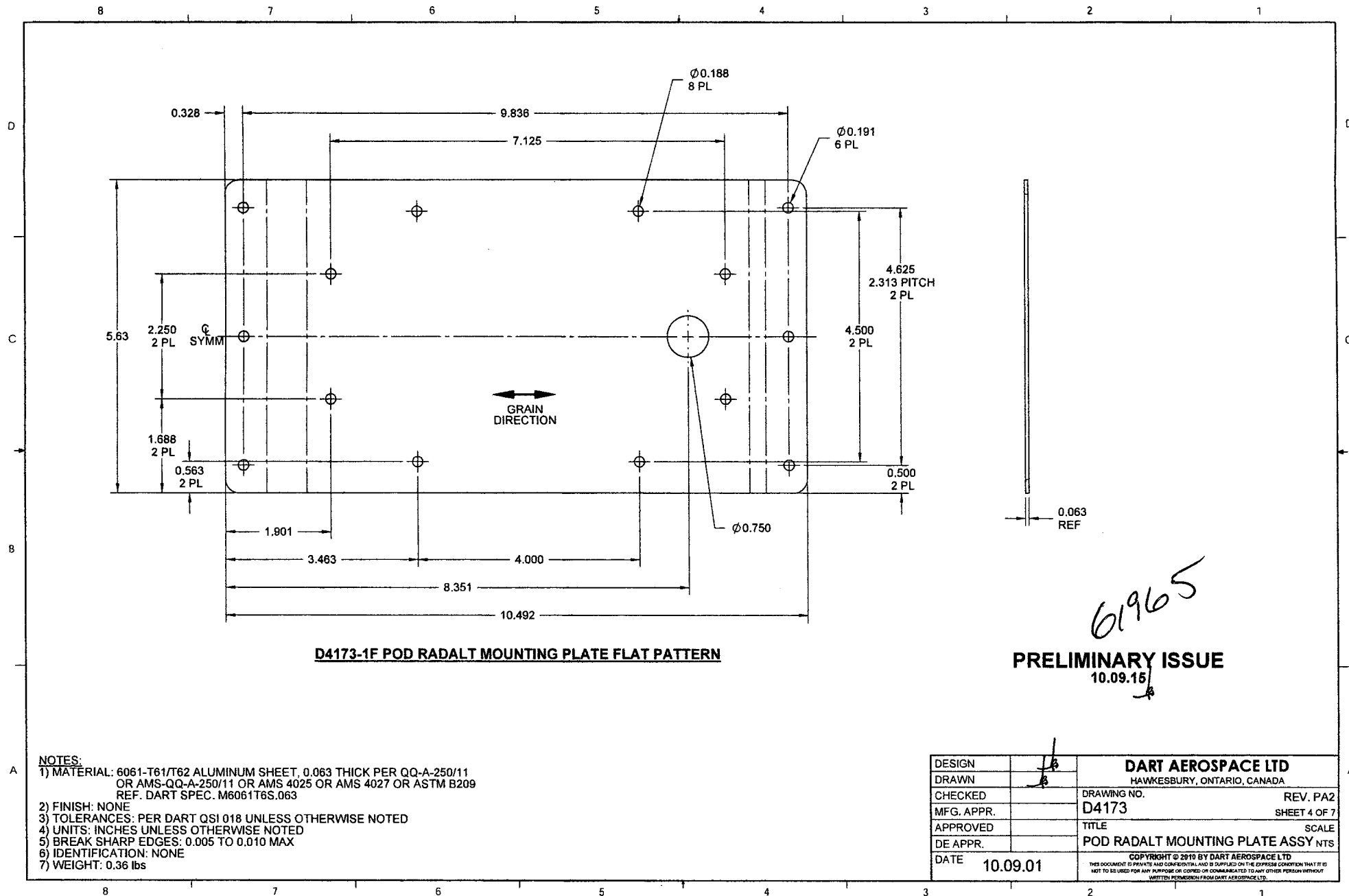


D4173-7 RADALT SCHIM

61965

PRELIMINARY ISSUE
10.09.15

PA2	REVISED GROOVE IN D4173-7; ADDED TOL ON D4173-7 THICKNESS	MB	10.09.15
PA1	NEW ISSUE	MB	10.09.01
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4173	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY	NTS
DATE	10.09.01	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

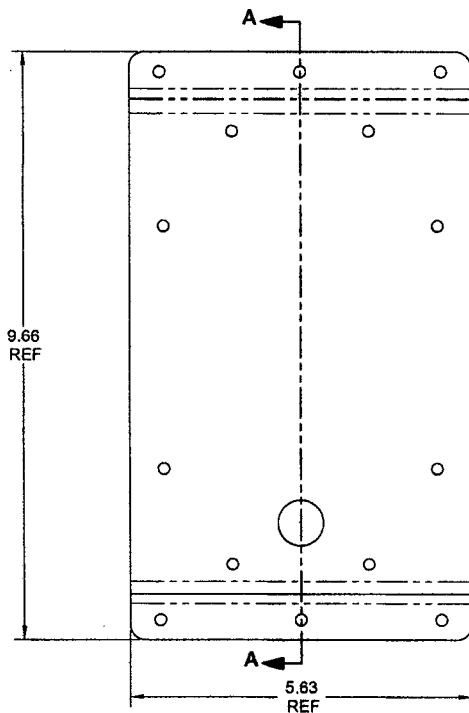


61965

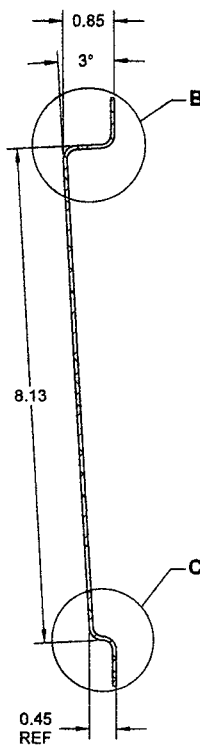
PRELIMINARY ISSUE
10.09.15

- NOTES:**
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.36 lbs

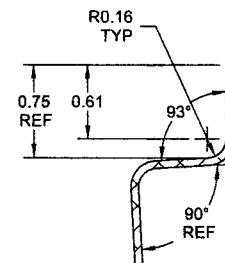
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4173	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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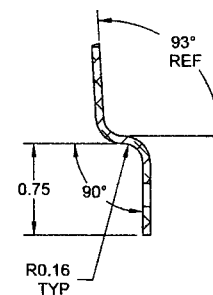
D4173-1 POD RADALT MOUNTING PLATE



SECTION A-A



**DETAIL B
SCALE 2X**

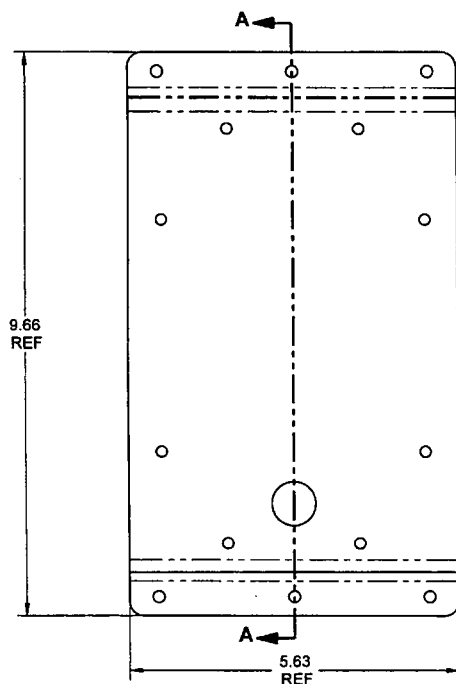


**DETAIL C
SCALE 2X**

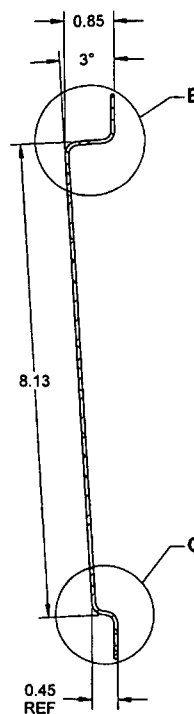
PRELIMINARY ISSUE
10.09.15

- NOTES:**
- 1) MATERIAL: MAKE FROM D4173-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.50 lbs

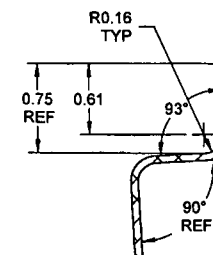
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA2
MFG. APPR.		D4173 SHEET 3 OF 7
APPROVED		TITLE SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS
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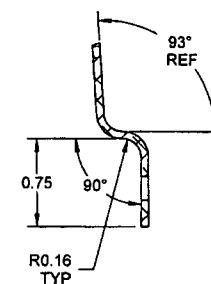
D4173-1 POD RADALT MOUNTING PLATE



SECTION A-A



DETAIL B
SCALE 2X



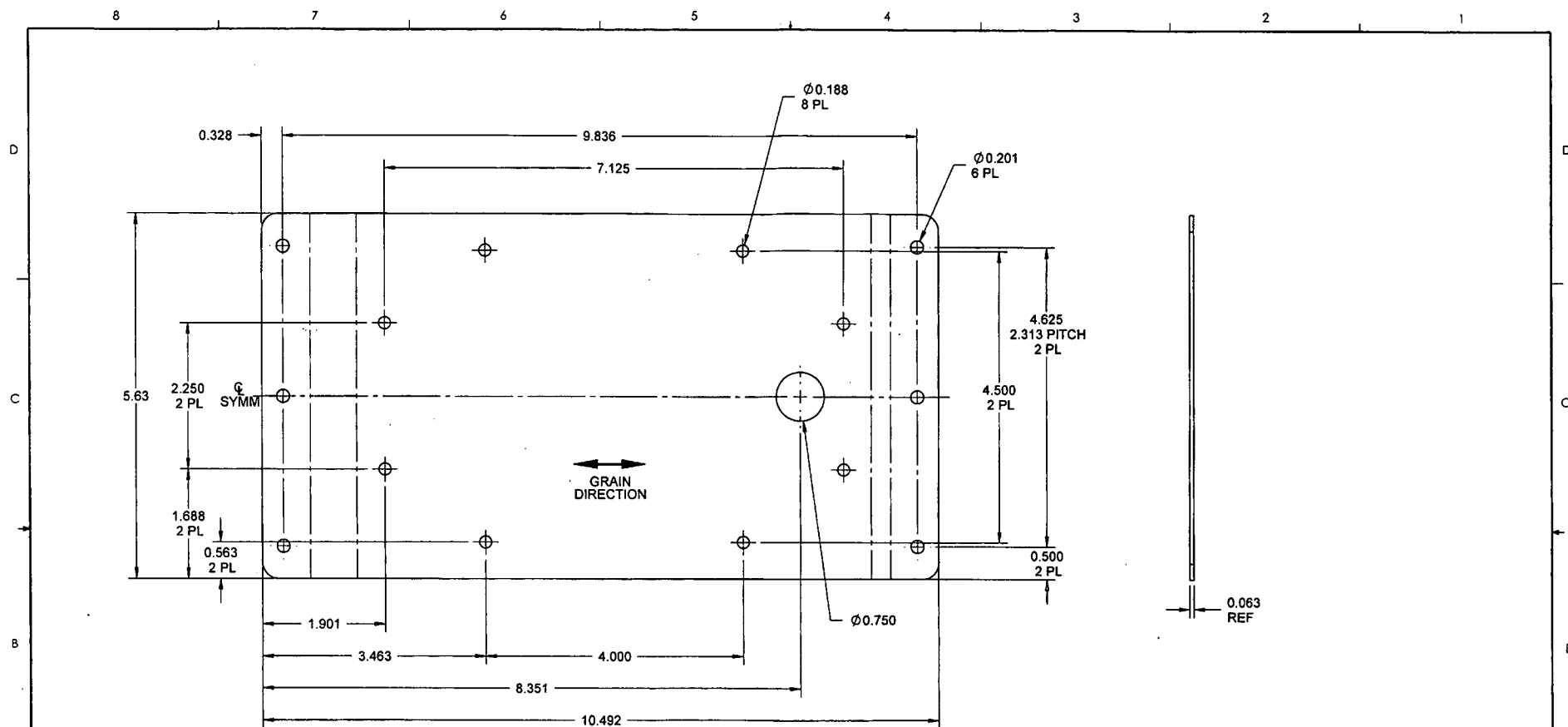
DETAIL C
SCALE 2X

- NOTES:**
- 1) MATERIAL: MAKE FROM D4173-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.50 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D4173	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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RELEASED
2010-09-29

61965









D4173-1F POD RADALT MOUNTING PLATE FLAT PATTERN

RELEASED
2010-09-29

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4173	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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